Amendments to the Specification:

Please replace the paragraph beginning on page 17, line 22 with the following amended paragraph:

The subsequent operations are as follows. First, as shown in Fig. 7, when the lower chuck 8 catches the lower end portion of the tool 2 and the upper chuck 4 releases the tool 2, the lower chuck 8 descends at a predetermined speed. After releasing the tool 2, the upper chuck 4 ascends, and **[[**the**]]** both ends of the upper lid 5 approach to each other in directions indicated by the arrows to close the upper lid 5. **[[**when**]]** When the lower chuck 8 brings the tool 2 down below the work 103 as indicated by the arrow, the lower lid 9 is closed.

Please replace the paragraph beginning on page 19, line 15 with the following amended paragraph:

When the hub unit is divided into three areas depending on the position of the lid, including an area higher than the upper lid **[[**4**]]** 5, an area lower than the lower lid 9, and an area between the upper lid **[[**4**]]** 5 and the lower lid 9, the cleaning of the tool 2 can be carried out when there is no work 103 and the

broaching work after plastically deforming by caulking (or clinching) can be conducted without attaching chips onto the work 103. In case of a spline processing which leaves very little chips, the broaching work may be conducted in a structure having an upper lid only and no lower lid, or in a structure having a lower lid only and no upper lid. In case of the spline formation and processing producing no chip, the broaching work is in some cases conducted in a structure with no lid.

Please replace the paragraph beginning on page 20, line 5 with the following amended paragraph:

As for a method of driving the chucks 4 and **[[9]]** 8, the upper chuck 4 is driven by an air cylinder and the lower chuck **[[9]]** 8 by a mechanism having a servo motor and a ball screw combined with each other, respectively. The driving method is not limited to this. The upper chuck 4 or the lower chuck **[[9]]** 8 may be driven by oil pressure.